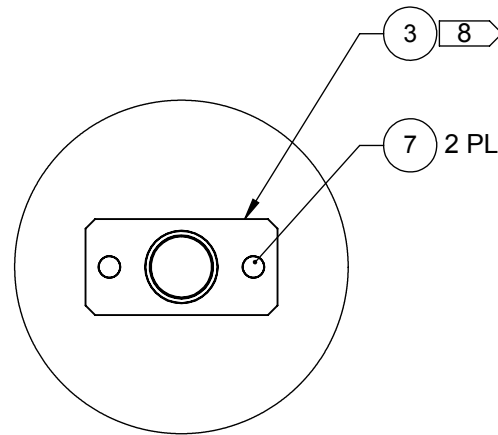
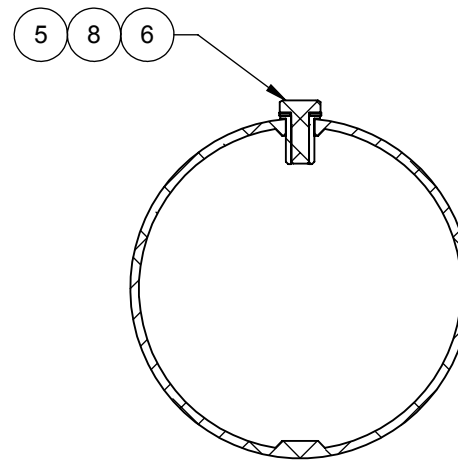




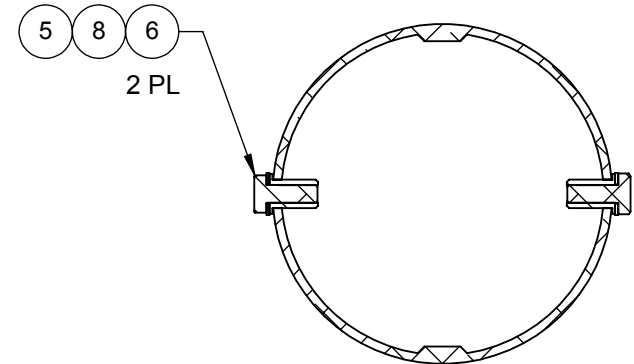
ITEM	QTY -043	P/N	DESCRIPTION
	X	D4766-043	SKIDTUBE SUB ASSY
1	2	D2973	SPACER
2	11	D4686-1	SPACER
3	22	D4753-1	DOUBLER
4	1	D4766-045	SKIDTUBE SUB ASSY
5	3	AELS-1032-130	INSERT
6	3	AN3C4A	BOLT
7	44	MS20601AD4W3	RIVET, BLIND, CSK
8	3	NAS1149F0332P	WASHER



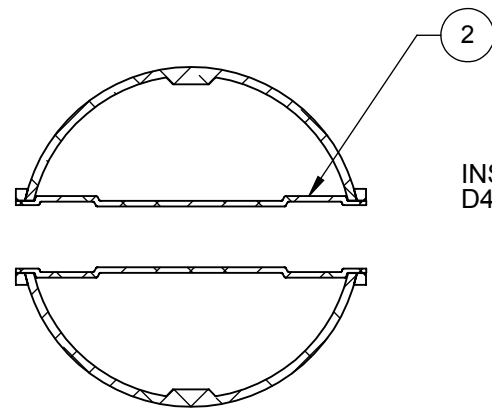
**DETAIL F**  
**SCALE 6X**  
**22 PL**



**SECTION E-E**  
SCALE 6X



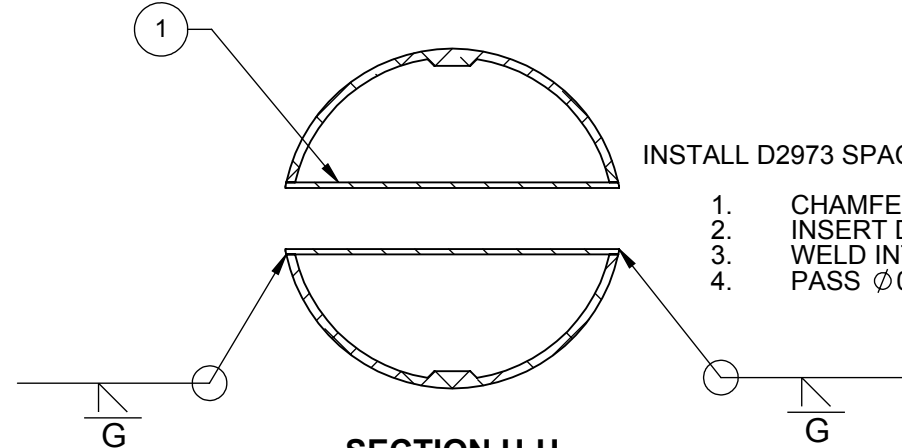
**SECTION G-G**  
SCALE 6X



**SECTION D-D**  
SCALE 6X  
11 PL

INSTALL D4686-1 SPACER AFTER INSTALLING  
D4753-1 DOUBLERS AS FOLLOWS (11 PL)

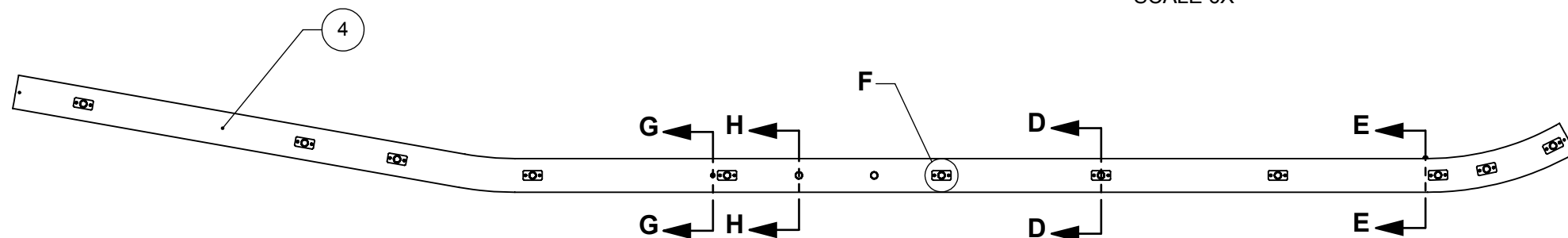
1. INSERT D4686-1 SPACER
2. SWAGE TO  $\varnothing 0.650 +0.010/-0.000$  X 1.0 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



**SECTION H-H**  
SCALE 6X

INSTALL D2973 SPACER AS FOLLOWS (2 PL)

1. CHAMFER HOLE 0.030X45 DEG
2. INSERT D2973 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS  $\varnothing 0.625$  DRILL TO REMOVE SPILL OVER



**D4766-043 SKIDTUBE SUB ASSY**

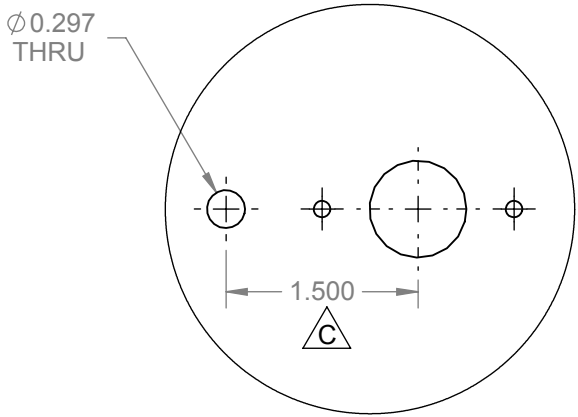
NOTES:

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
APPLY SHERWIN WILLIAMS PRIMER (CM0483928) PER DART QSI 005 4.2  
PAINT TWO COATS OF SHERWIN WILLIAMS (CM0143603GA) GLOSS WHITE PER DART QSI 005 4.2  
APPLY TWO COATS OF SHERWIN WILLIAMS CLEAR COAT (CM0571080) PER DART QSI 005 4.2
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 31.69 lbs
  - 8) SEAL FAYING SURFACES USING PROSEAL P/S 890 OR MIL-S-8802 CLASS B2 SEALANT
  - 9) WELDING: PER QSI 004

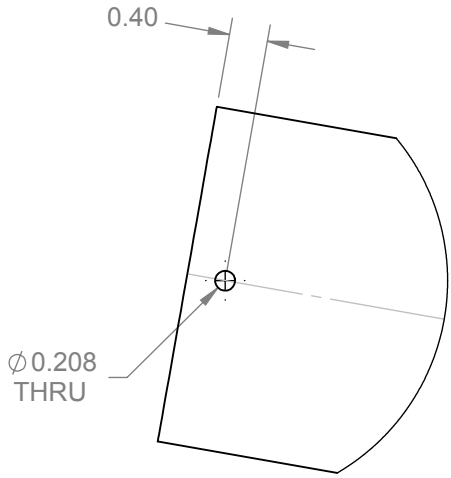
PRELIMINARY ISSUE

DESIGN	AP	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO. <b>D4766</b>	REV. C1
MFG. APPR.	DD		SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>SKIDTUBE</b>	NTS
DATE <b>14.10.15</b>		<b>COPYRIGHT © 2014 BY DART AEROSPACE USA, INC.</b> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

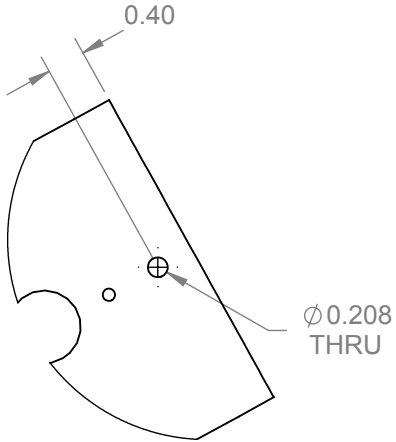
ITEM	QTY -045	P/N	DESCRIPTION
	X	D4766-045	SKIDTUBE SUB ASSY
1	1	D4766-1	SKIDTUBE
2	1	D5085-1	WEB



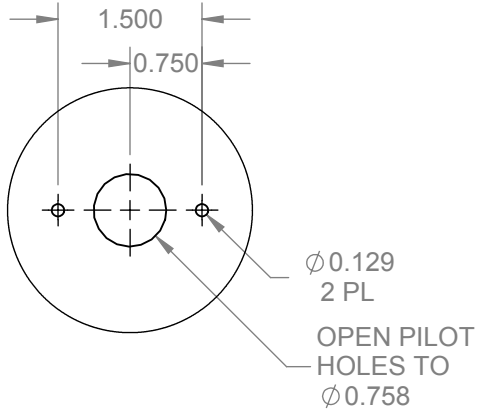
**DETAIL L**  
SCALE 4X



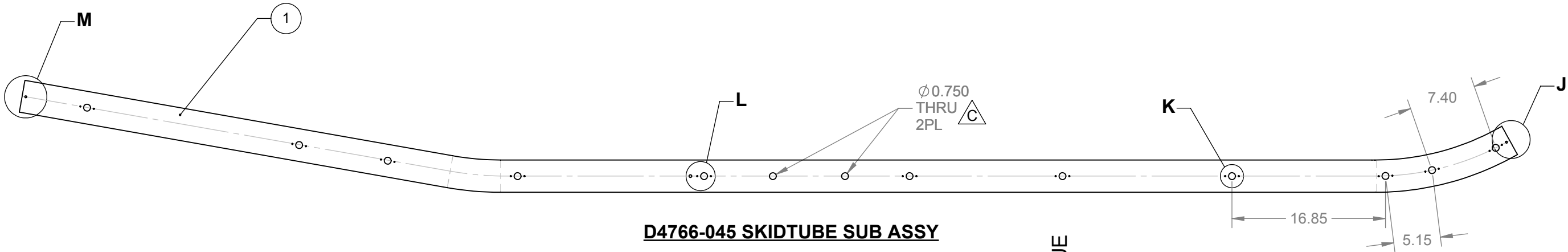
**DETAIL M**  
SCALE 6X



**DETAIL J**  
SCALE 6X



**DETAIL K**  
11 PL (BOTH SIDES)  
SCALE 6X

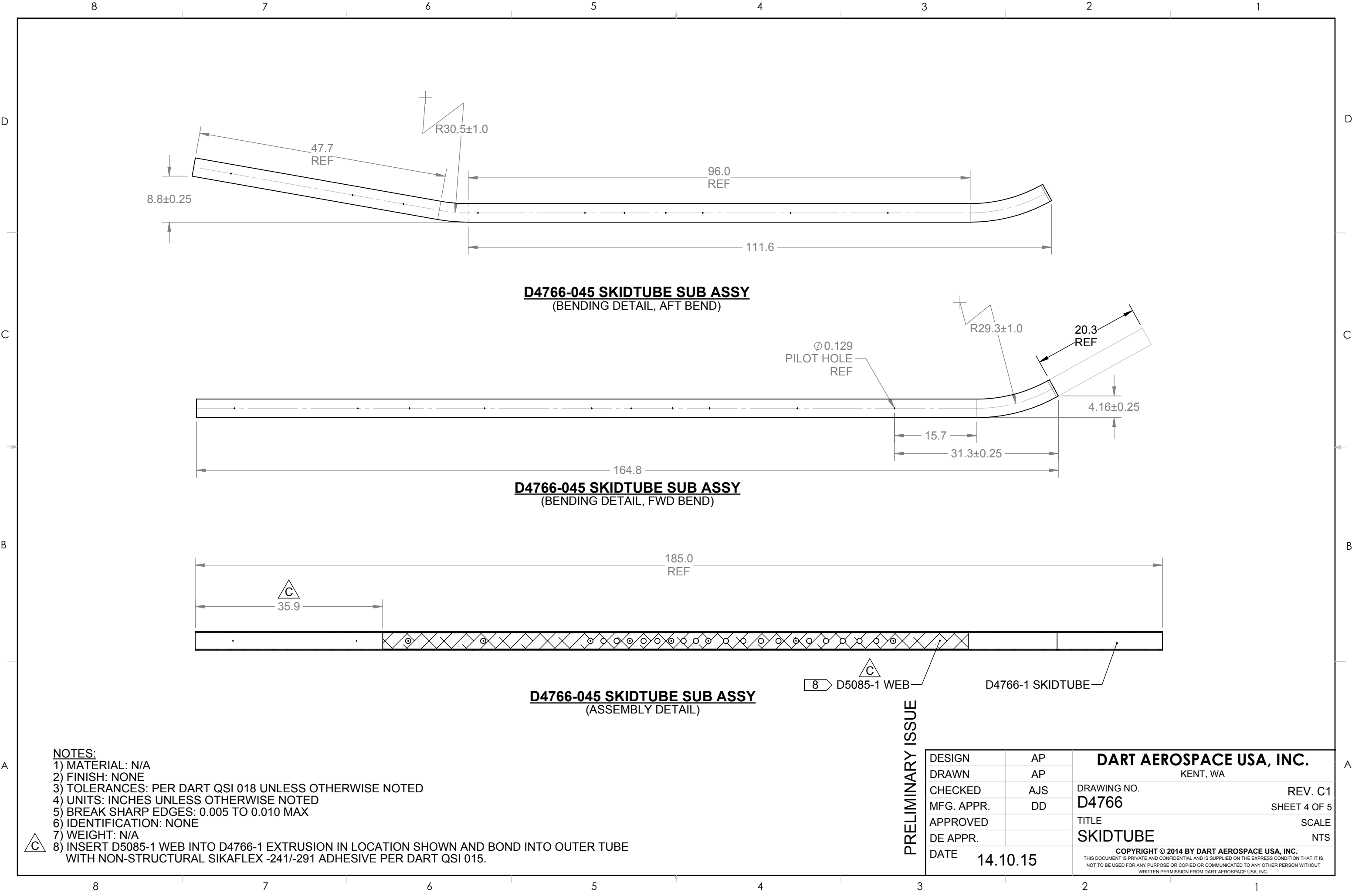


**D4766-045 SKIDTUBE SUB ASSY**

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 31.69 lbs

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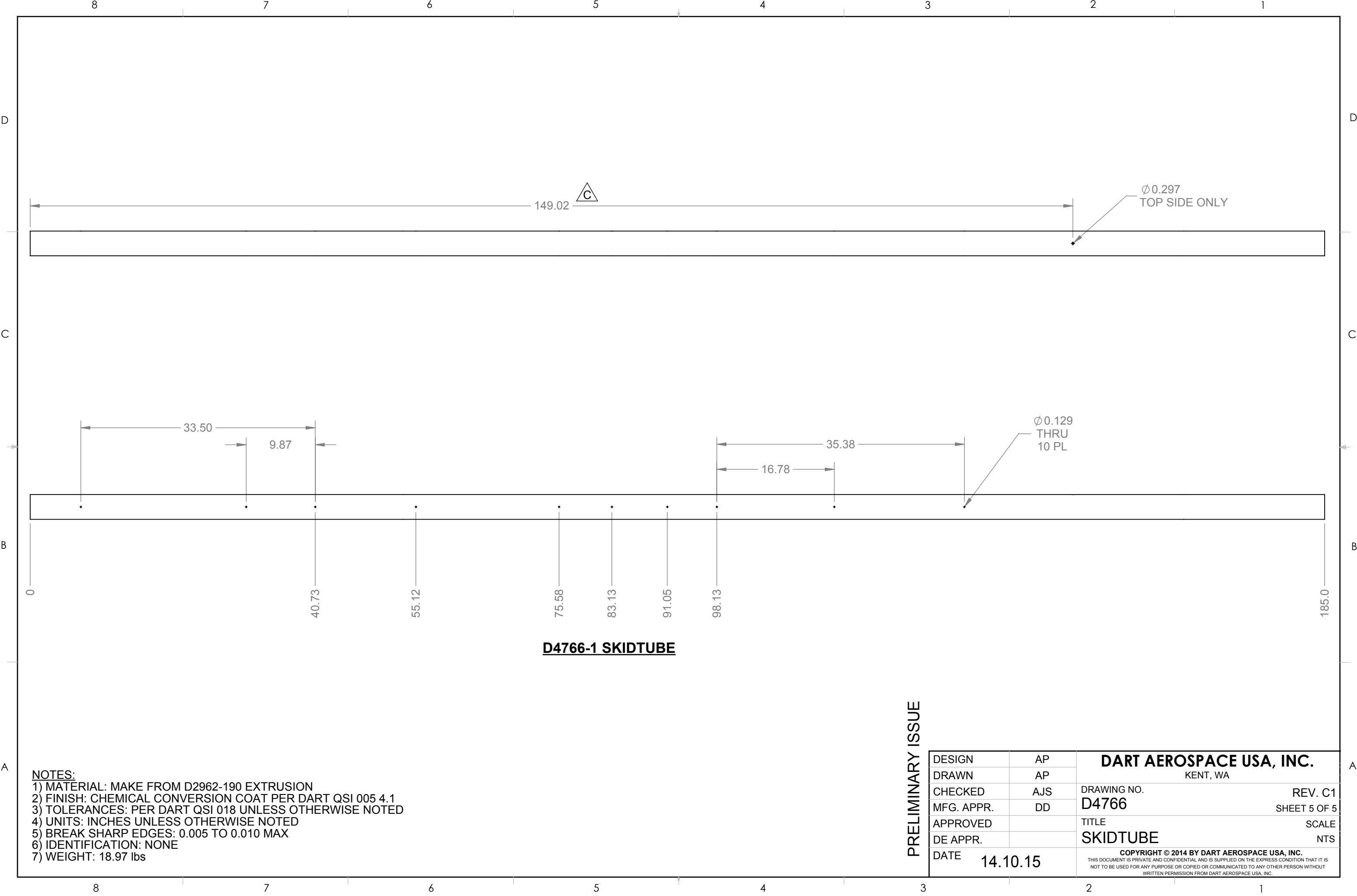


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) INSERT D5085-1 WEB INTO D4766-1 EXTRUSION IN LOCATION SHOWN AND BOND INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015.

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